

# Work Order ID 48528

July 1, 2009 7:37:37 AM



Page 1

Item ID: D2199-25

Accept



Setup Start



Revision ID: E1

Stop



Item Name: Strut Details

Start Date: 07/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2199

Rev E1

100

0.00



Brake NC

Memo

0.00

Brake NC

Punch per Dwg D2199 and Spec Contol Dwg D2638

SB 09/07/07 (4)

110

0.00



Small Fab

Memo

0.00

Small Fab

Debur

M. H 09/07/07 (4X)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=>

809/07/07 (X)

# Work Order ID 48528

July 1, 2009 7:37:37 AM

Page 2

Item ID: D2199-25

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Required Date: 08/03/2009 Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time: 3:00pm

Oven Temperature: 400°F

Finish Time: 3:30pm

M111472 09-07-07 (X4)

Handwritten signature

140

QC3- Inspect Part Finish

0.00

09-07-8

(4)

BR.



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 241

0.00



Packaging

Memo

0.00

Packaging

9/7/8 SV (4)

**Work Order ID 48528**

Page 3

July 1, 2009 7:37:37 AM

Item ID: D2199-25

Accept



Setup Start



Revision ID: E1

Stop



Item Name: Strut Details

Start Date: 07/15/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/09 *[Signature]*

MF 09-07-09

# Picklist Print

July 1, 2009 7:37:36 AM

Work Order ID: 48528

Parent Item: D2199-25RevE1

Parent Item Name: Strut Details

Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

M304TR0.750W.049

Purchased

No

100

f

176.8673

7.0876



111619 5/6/09/07/02 (4)

304 RD Tube .750 x .049W

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

176.86

107518

7.27

108498

0

109314

8.5

110113

0.73

110271

0.03

111096

9

111457

11.43

111619

139.9

Date: Friday, 12/06/2009 9:53:34 AM  
 User: Julie Dawson

## Process Sheet

|                                    |  |                           |               |
|------------------------------------|--|---------------------------|---------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services          | <b>Drawing Name</b> :     | STRUT         |
| <b>Job Number</b> :                | 48528  |                           |               |
| <b>Estimate Number</b> :           | 10220  |                           |               |
| <b>P.O. Number</b> :               |  | <b>Part Number</b> :      | D219925       |
| <b>This Issue</b> :                | 12/06/2009                                   | <b>S.O. No.</b> :         |               |
| <b>Prsht Rev.</b> :                | NC   | <b>Drawing Number</b> :   | D2199 / D2638 |
| <b>First Issue</b> :               | / /  | <b>Project Number</b> :   | N/A           |
| <b>Previous Run</b> :              | 43597  | <b>Drawing Revision</b> : | E1/A          |
|                                    | <b>Type</b> :                                | <b>Material</b> :         |               |
|                                    | SMALL / MED FAB                              | <b>Due Date</b> :         | 22/06/2009    |
| <b>Written By</b> :                |  | <b>Qty:</b>               | 4 Um: Each    |
| <b>Checked &amp; Approved By</b> : | <u>JUDY.OL.12</u>                            |                           |               |
| <b>Comment</b> :                   | Est:D 02.06.10 Rmv polish & add finish NG/RF |                           |               |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |                |                          |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



**Comment:** Qty.: 1.7675 f(s)/Unit Total : 7.0699 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: ~~M304TR~~ M111619 SB 09/07/07

|     |          |          |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



**Comment:** BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SB 09/07/07

|     |             |                               |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

M111472 09/07/07

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



**Comment:** INSPECT WORK TO CURRENT STEP

SB 09/07/07

|     |                |                |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



**Comment:** POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 3:00pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:30pm

SB 08-07-07

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 12/06/2009 9:53:34 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 48528

Part Number: D219925

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion/



**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

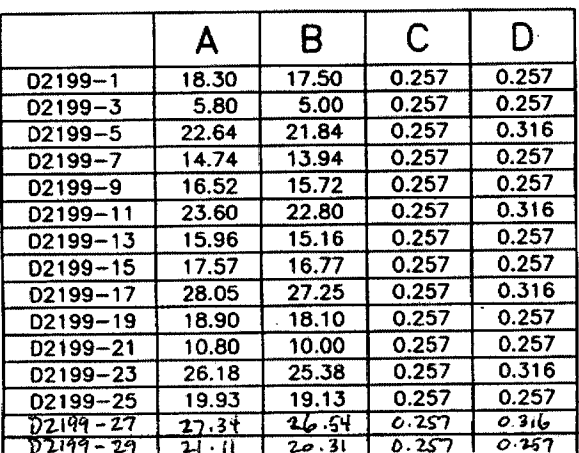
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |


**NOTE:** Date & initial all entries





RELEASED  
48.05.05 KE



1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER  
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL  
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 

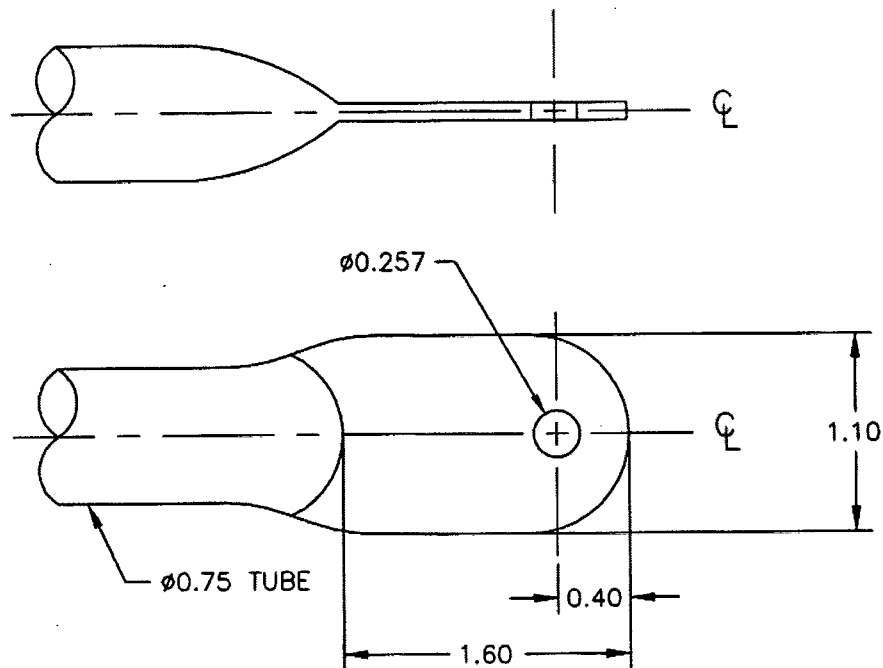
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WITHOUT NOTICE



|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>KE     | DRAWN BY<br>KE | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>ME    | APPROVED<br>KE | DRAWING NO.<br>D2638                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br>98.04.28 |                | TITLE<br>PUNCH DT8117 SPEC CONTROL                | SCALE<br>1:1           |
| A                | 98.04.28       | NEW ISSUE   |                        |

RELEASED  
4/5/05 KE

SPECIFICATION CONTROL DRAWING  
FOR PUNCH DT8117



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